

14-4 450

**Work Order ID 69005**

Wednesday, April 27, 2011 10:44:10 AM



Page 1

Item ID: D3407-1

Accept



Setup

Start



Revision ID:

Item Name: Stem

Stop



Start Date: 4/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *H*

Date: 11-04-27

Tooling:

Date:

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100



DOOSAN LATHE

Doosan

Doosan Lathe

Memo

0.00

*20 11-6-1*
*20*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

*RP 11-6-1*
*20*

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

*11-6-2*
*20*

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 69005**

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Page 2

Item ID: D3407-1

Accept



Setup

Start



Revision ID:

Item Name: Stem

Stop



Start Date: 4/27/2011 Start Qty: 20.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: WASet Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*116125* *20*

*n/a*

*MF*  
*11-06-03*

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NOTE: Date & initial all entries

# Picklist Print

Page 1

Wednesday, April 27, 2011 10:44:16 AM

Work Order ID: 69005



Parent Item: D3407-1



Parent Item Name: Stem

Start Date: 4/27/2011

Required Date: 4/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased		No		100	f	7.6500	0.366	7.705263		2011-04-27	11-6-1

17-4 round bar .750



Location                    Loc Qty                    Loc Code

MAT030                    7.65

116808                    7.65

771082

2.3

6.75

9.05

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD	Work Order:	69005
Description: Tow Ring	Part Number:	D3407-1
Inspection Dwg: D3407 Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/		20.02	
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/		20.05	
Major Ø	Max: 0.249 Min: 0.2425	.243	/		"	
Ø0.625	+/-0.010	.622	/		20.02	
Ø0.363	+/-0.010	.363	/			
Ø0.750	+/-0.010	.749	/			
R0.100	+/-0.010	2.100	/			
0.470	+/-0.010	.470	/			
0.500	+/-0.010	.502	/			
3.250	+/-0.010	3.250	/			
4.250	+0.000/-0.010	4.244	/			
5.270	+/-0.010	5.275	/			
0.150	+/-0.010	.157	/			
0.550	+/-0.010	.550	/			
0.625	+/-0.010	.622	/			
0.250	+0.010/-0.000	.252	/			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11 - 6 - 1	Date:	11/6/2	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.07.18	Tolerances for diameters updated per Machinists	KJ/JLM	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	

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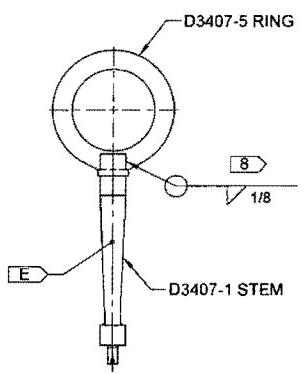
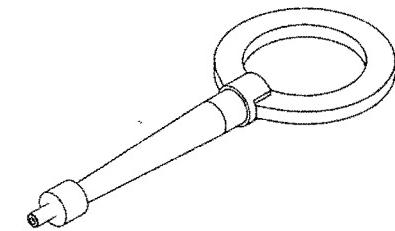
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

E

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X	X	D3407-041	TOW RING	
	X	D3407-043	TOW RING	
	X	D3407-045	TOW RING	
1		D3407-1	STEM	
1	1	D3407-3	STEM	
1	1	D3407-5	RING	
	1	D3407-7	STEM	

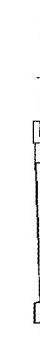
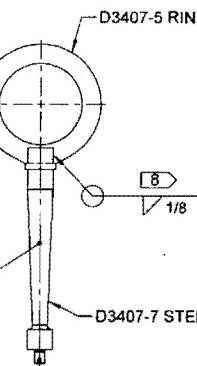
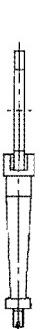
SHOP COPY  
RETURN TO  
ENGINEERING.  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 19005  
P110429



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING E

RELEASED  
08.07.23

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER E
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3407	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOW RING	NTS
DATE	08.07.23	Copyright © 2005 by DART Aerospace USA, Inc. This document is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without written permission from DART Aerospace USA, Inc.	

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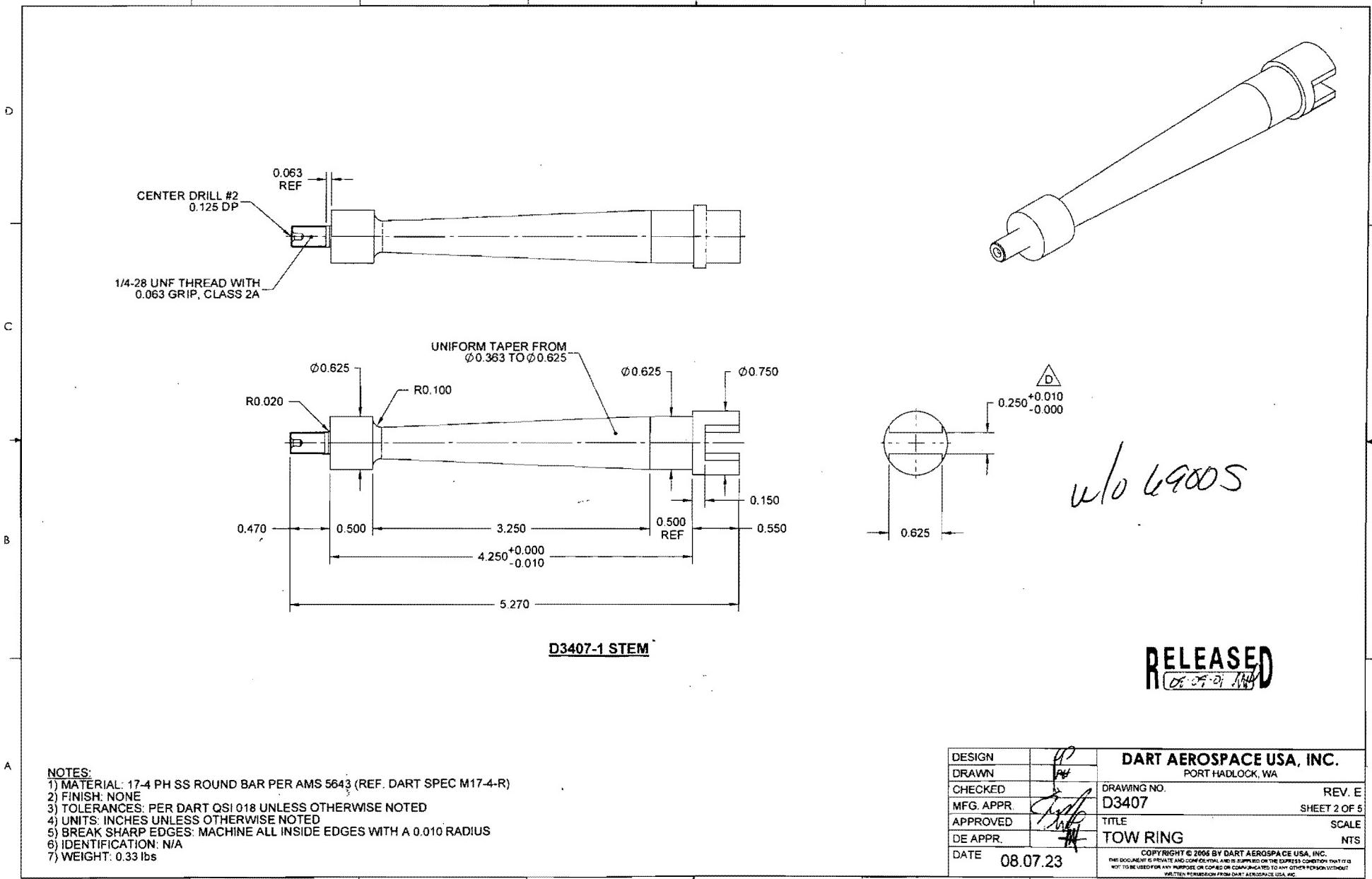
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8 7 6 5 4 3 2 1



DESIGN	<i>P</i>	DART AEROSPACE USA, INC.
DRAWN	<i>P</i>	PORT HADLOCK, WA
CHECKED	<i>J</i>	DRAWING NO. REV. E
MFG. APPR.	<i>J</i>	D3407 SHEET 2 OF 5
APPROVED	<i>J</i>	TITLE SCALE
DE APPR.	<i>J</i>	TOW RING NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THE DOCUMENT CONTAINED HEREIN IS UNCLASSIFIED AND MAY BE COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

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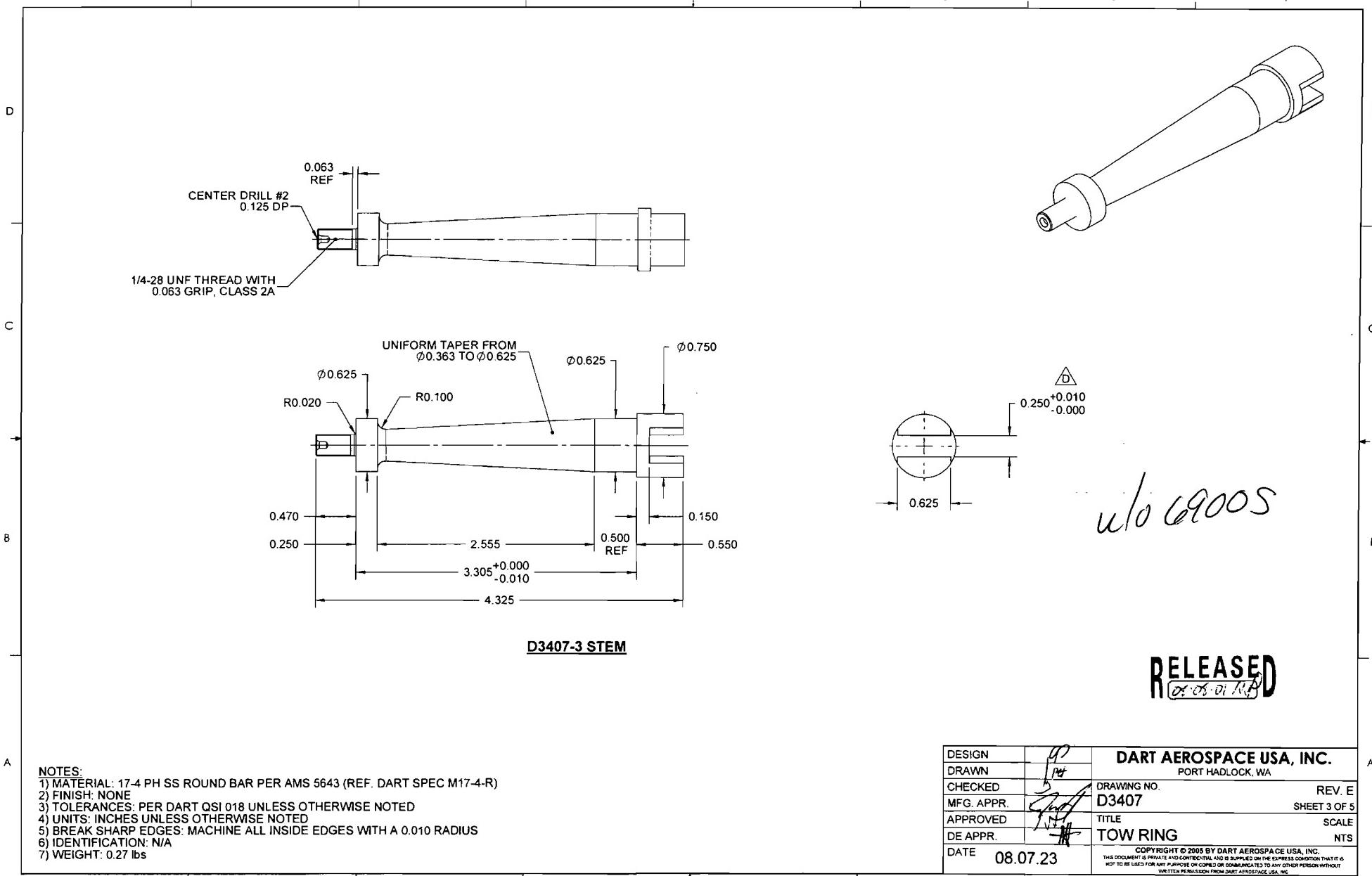
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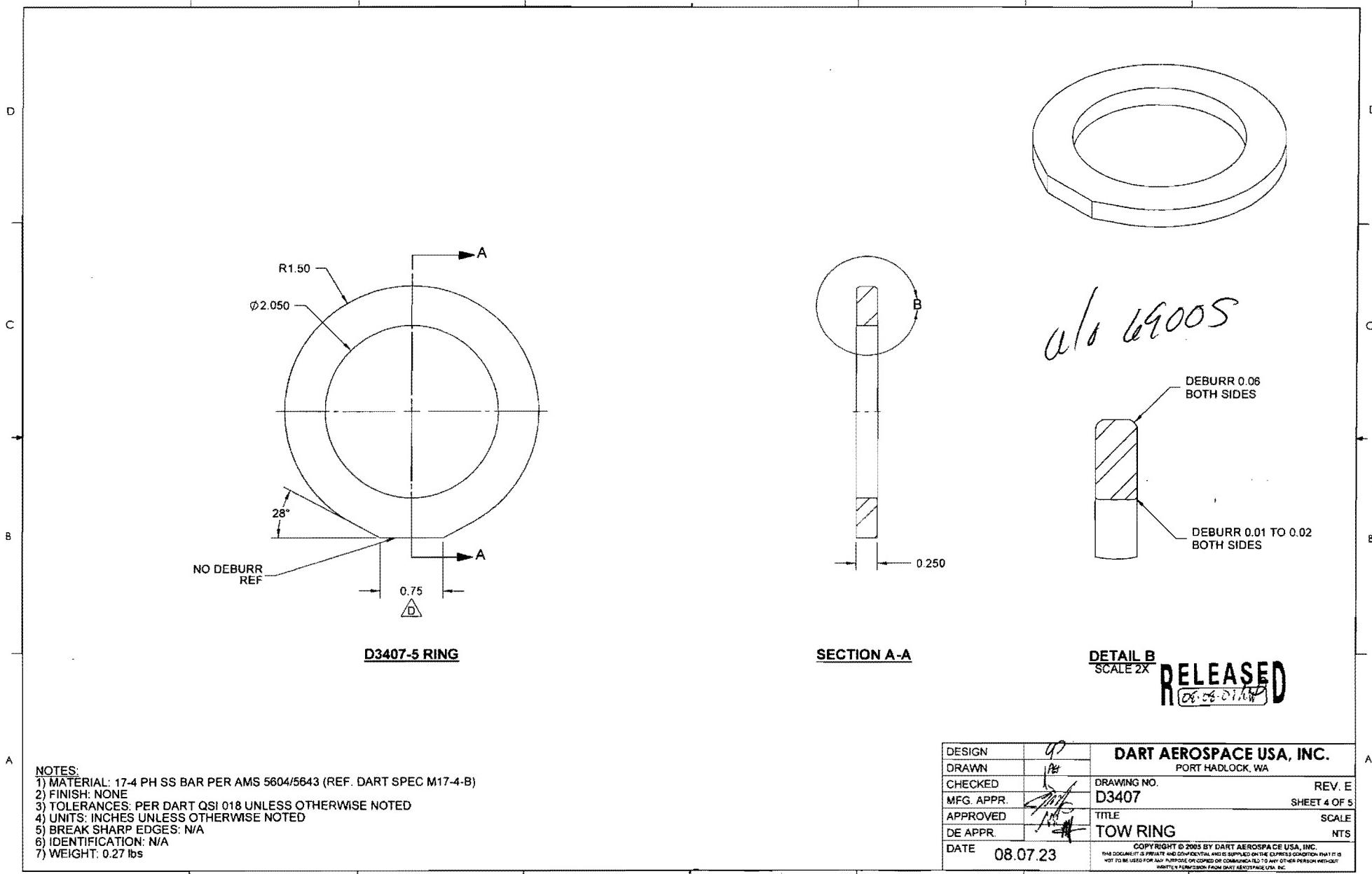
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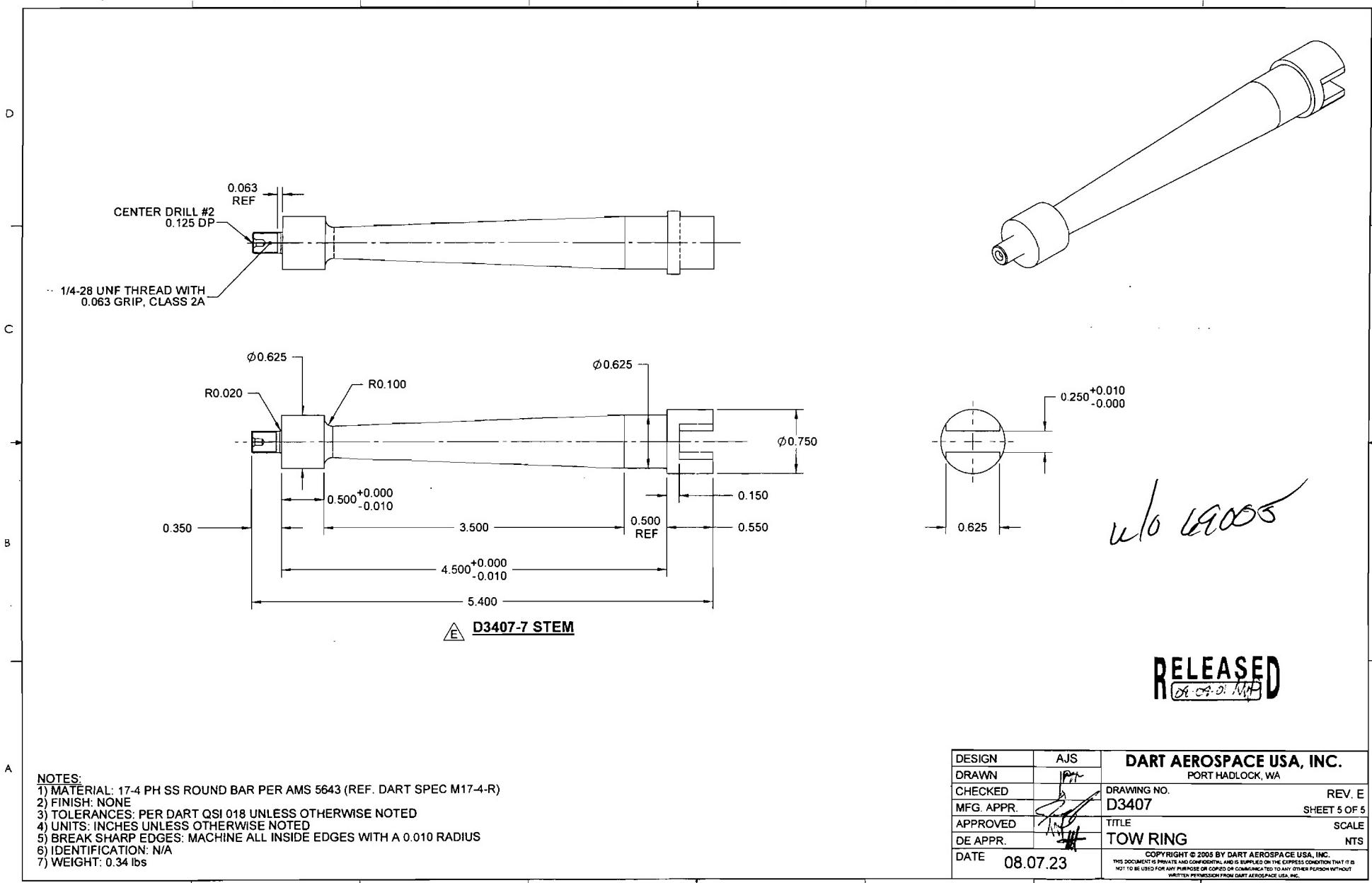
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